

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021262**Date Inspected:** 05-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

OBG Segment 9BE-9CE

Shielded Metal Arc Welding (SMAW) in the 3G position of Side Panel repair area at Bike Path side, weld joint OBE9B-009 as per repair report # B-WR-13917. The welder is identified as 048659. ZPMC Quality Control (QC) is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G(3F)-FCM-Repair-1. See attached photograph Pic_001

OBG Segment 9AW-9BW

Shielded Metal Arc Welding (SMAW) in the 4G position of Counterweight side Edge Panel to Side Panel hold back area from inside, weld joint 9AW-CA055-006 & 9BW-CA59-002. The welder is identified as 037996. ZPMC Quality Control (QC) is identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1. See attached photograph Pic_002

OBG Segment 9BE-9CE

WELDING INSPECTION REPORT

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Flux Core Arc Welding (FCAW) in the 1G position of Bike Path side LD # LD12B web edge was being built up as per Repair Report # B-WR-13818. The welder is identified as 220069. ZPMC Quality Control (QC) is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-1G(1F)-FCM-Repair-1.

OBG Segment 9BE-9CE

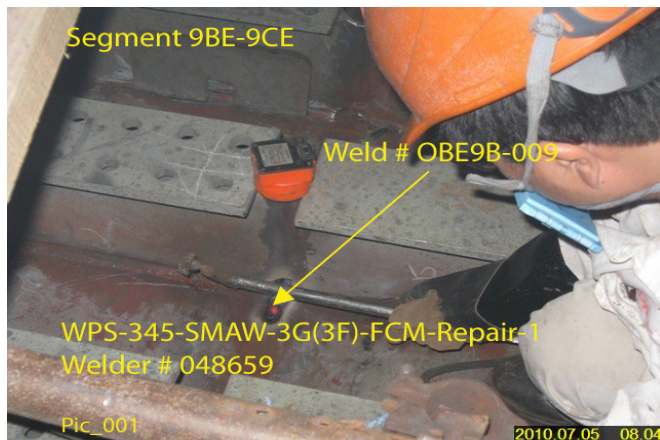
During in process visual inspection of 9BE-9CE, This QA Inspector observed ZPMC NDT personnel performing Magnetic Particle Testing (MT) on Bottom Panel 'T' Ribs holdback area welds.

OBG Segment 11BW

This QA inspector performed Magnetic Particle Testing (MT) approximately 15% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as PP99W-Deck Panel Diaphragm to Floor Beam Flange weld.

The weld designations reviewed are as follows:

SSD11-PP099-003



Summary of Conversations:

No relevant conversations reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

Inspected By: Gade,Ramesh

Quality Assurance Inspector

Reviewed By: McClendon,Timothy

QA Reviewer